

Work Order ID 65797

Wednesday, January 26, 2011 10:08:09 AM

POSITIVE RECALL
~~PRELIMINARY ISSUE~~
RELEASED DATE

Page 1

Item ID: D4038-12

Accept

Setup Start

Revision ID:

Stop

Item Name: Block

Start Date: 1/26/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4038

B C 11.01.27

100

0.00

11.1.27

2

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.750" LONG

105

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA886

DWG REV: PC1

FOLIO REV: AA

11.1.27

2

DEBURR

Work Order ID 65797

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Page 2

Item ID: D4038-12

Accept

Setup Start

Revision ID:

Stop

Item Name: Block

Start Date: 1/26/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

11.1.27 2

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

B.A 11/01/27 2 6

QC

Memo

0.00

Quality Control

*PART MADE TO REV. PC1
NO CHANGE FROM REV. B 11.01.31
NO CHANGE AT REV. C*

130

Chemical Conversion Coat per QSI005 4.1

0.00

2 BR 11-01-08

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 65797

Wednesday, January 26, 2011 10:08:09 AM

Page 3

Item ID: D4038-12

Accept

Setup Start

Revision ID:

Stop

Item Name: Block

Start Date: 1/26/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/28/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

ES 11/01/31 (2)

160

Identify as per dwg & Stock Location: GA

0.00

Packaging

Memo

0.00

Packaging

w/o 65791

ES 11/01/31 (2)

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/31 DJ

CL 11/01/31

Picklist Print

Wednesday, January 26, 2011 10:08:06 AM

Page 1

Work Order ID: 65797

Parent Item: D4038-12

Parent Item Name: Block

Start Date: 1/26/2011

Required Date: 1/28/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	13.7074		0.349474			

6061-T6 Bar 1.50 x 2.00

Location

Loc Qty

Loc Code

MAT

12

114608

12

MAT10

1.7074

110167



1.7074


11-1-27
291

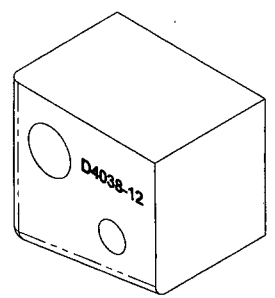
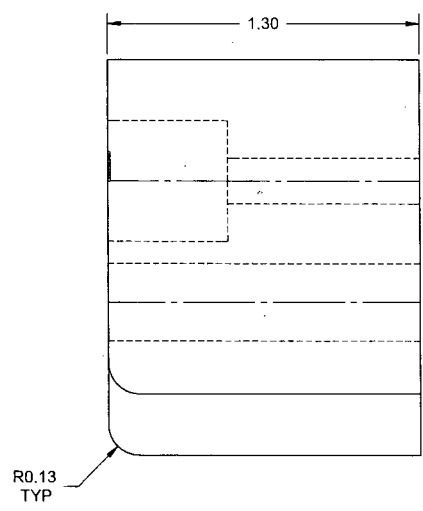
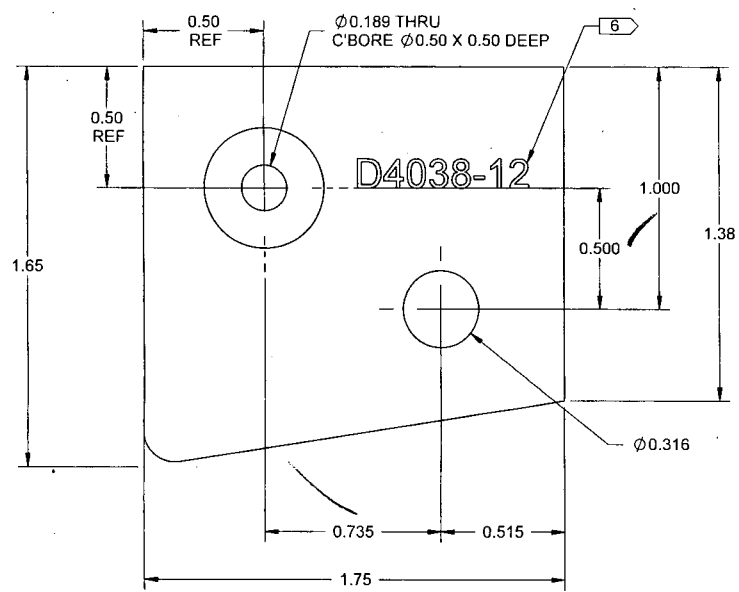
DART AEROSPACE LTD		Work Order:	65717
Description: Block		Part Number:	D4038-12
Inspection Dwg: D4038	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: 	Audited by: 	Preliminary Approval:
Date: 11-1-27	Date: 11/01/27	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	



D4038-12 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

PRELIMINARY ISSUE

11.01.20

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		D4038	SHEET 14 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.01.20	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

